

ABSTRACT

5 A blow mold assembly for an I.S. machine for
blowing a parison of glass and cooling the blown parison
into a formed bottle which can be removed from the blow
mold. A blow head is lowered onto a blow mold and final
air is applied. The blow head is lifted a selected
vertical distance above the top surface of the blow mold
to an exhaust position allowing cooling air to escape
10 from the blow mold. The selected vertical distance is
selected so that at least a minimum pressure will
continue within the formed bottle. The blow head is
maintain at the exhaust position for a predetermined time
and then retracted. A first pressure is applied while
15 the blow head is at the lowered position and a higher
pressure is applied while the blow head is at the escape
position.